

Date: Tuesday, 15/07/2008 4:11:58 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
<b>Job Number</b> :	40514	<b>Part Number</b> :	D2571		
<b>Estimate Number</b> :	10530	<b>Drawing Number</b> :	D2571 REV E		
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A		
<b>This Issue</b> :	15/07/2008	<b>S.O. No.</b> :		<b>Drawing Revision</b> :	E
<b>Prsht Rev.</b> :	NC	<b>Type</b> :	MACHINED PARTS		
<b>First Issue</b> :	/ /	<b>Material</b> :			
<b>Previous Run</b> :	39806	<b>Due Date</b> :	08/08/2008	<b>Qty:</b>	10 Um: Each
<b>Written By</b> :					
<b>Checked &amp; Approved By</b> :	<u>JUL 08.7.16</u>				
<b>Comment</b> :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ				

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2571  
 Ensure that grain is along 7.75" length  
 Batch No: B34875

ML 08/08/13

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 40514 Double check by: JA

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

(PTO)

ML / J.F. 08/08/15 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

J.F. 08/08/15 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/08/15 (10)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2571 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: ✓ Date: 08.08.27  
D412-742-03/011 QA: N/C Closed: ✓ Date: 09/08/26

NCR: <u>40514</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/13	2.0	1 part scrap, the skid bolt pattern too thin. R.C. the part start to vibrate	<u>[Signature]</u> 08/08/13	scrap and destroy and replace Qty: 1 Batch: <u>34875</u>	<u>[Signature]</u> 08/08/13	<u>[Signature]</u> 08/08/13	<u>[Signature]</u> 08/08/13	<u>[Signature]</u> 08/08/13

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 40514

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SF 08/08/19

(10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M2

08/08/19

(10)

7.0

POWDER COATING

POWDER COATING



M108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:45

OVEN TEMPERATURE:

320°C

FINISH TIME:

12:15

M-L

08/08/19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BP

08-08-19

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 21 432

08/08/21

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



MF 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40514
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	φ.439	φ.439	φ.439"		
B	1.745	1.755		1.750	S	1.749"	1.750"		
C	3.495	3.505		3.500	C	3.501"	3.501"		
D	1.745	1.755		1.750	C	1.744"	1.750"		
E	7.990	8.010		8.000	R	8.005"	8.005"		
F	0.490	0.510		.502	A	.502"	.504"		
G	0.257	0.262		.258	259	.260	.259		
H	0.375	0.380		.378	1.378	.378	.378		
I	0.490	0.510		.499	.498	.499	.498		
J	1.174	1.184		1.177	1.178	1.179	1.178		
K	0.558	0.578		.565	.566	.565	.563		
L	1.174	1.184		1.177	1.178	1.179	1.178		
M	1.490	1.500		1.494	1.495	1.494	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.870	3.874	3.873		
P	0.115	0.135		.126	.126	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.251	.251		
S	0.115	0.135		.130	.132	.131	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.959	2.960	2.960		
V	0.230	0.250		.240	.240	.238	.238		
W	0.115	0.135		.120	.123	.122	.122		
X	0.308	0.313		.309		.309"	.309"		
Y	0.760	0.765		.766		.760"	.760"		
Z	0.352	0.372		.363		.363"	.370"		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.631		.635"	.630"		
AC	0.053	0.073		.063		.063"	.063		
AD	0.240	0.260		.245	.247	.246	.247		
AE	1.375	1.395		1.387	1.387	1.390	1.390		
AF	0.115	0.135		.130	.132	.131	.131		
AG	0.240	0.280		.260	.260	.266	.260		
AH	0.240	0.260		.250	.249	.247	.246		
AI	2.000	2.020		2.000	2.000	2.004	2.005		
AJ	0.023	0.043		.033	.033"	.033"	.033"		
Accept/Reject									

Measured by: <i>SM / J.F.</i>
Date: 08/08/13

Audited by: <i>SB</i>
Date: 08/08/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40514
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443	0	0.439"	0.439"	0.439"	0.439"		
B	1.745	1.755		1.749"	1.749"	1.749"	1.749"		
C	3.495	3.505		3.501"	3.501"	3.501"	3.501"		
D	1.745	1.755		1.749"	1.749"	1.749"	1.749"		
E	7.990	8.010		8.005"	8.005"	8.005"	8.005"		
F	0.490	0.510		0.505"	0.510"	0.508"	0.510"		
G	0.257	0.262		0.258"	0.258"	0.258"	0.258"		
H	0.375	0.380		0.376"	0.377"	0.377"	0.377"		
I	0.490	0.510		0.500"	0.502"	0.503"	0.503"		
J	1.174	1.184		1.182"	1.182"	1.182"	1.182"		
K	0.558	0.578		0.562"	0.566"	0.567"	0.565"		
L	1.174	1.184		1.180"	1.180"	1.180"	1.180"		
M	1.490	1.500		1.499"	1.499"	1.499"	1.499"		
N	2.495	2.505		2.502"	2.502"	2.502"	2.502"		
O	3.869	3.879		3.874"	3.874"	3.874"	3.874"		
P	0.115	0.135		0.126"	0.126"	0.126"	0.126"		
Q	0.115	0.135		0.127"	0.127"	0.127"	0.127"		
R	0.240	0.260		0.252"	0.252"	0.252"	0.252"		
S	0.115	0.135		0.130"	0.130"	0.130"	0.135"		
T	0.178	0.198		0.188"	0.188"	0.188"	0.188"		
U	2.940	2.980		2.959"	2.959"	2.959"	2.959"		
V	0.230	0.250		0.241"	0.241"	0.242"	0.241"		
W	0.115	0.135		0.122"	0.122"	0.124"	0.123"		
X	0.308	0.313		0.308"	0.309"	0.311"	0.311"		
Y	0.760	0.765		0.760"	0.760"	0.760"	0.760"		
Z	0.352	0.372		0.372"	0.372"	0.372"	0.372"		
AA	0.470	0.530		0.500"	0.500"	0.500"	0.500"		
AB	0.615	0.635		0.633"	0.633"	0.632"	0.632"		
AC	0.053	0.073		0.063"	0.063"	0.063"	0.063"		
AD	0.240	0.260		0.260"	0.260"	0.250"	0.250"		
AE	1.375	1.395		1.390"	1.389"	1.390"	1.389"		
AF	0.115	0.135		0.125"	0.125"	0.125"	0.125"		
AG	0.240	0.280		0.246"	0.246"	0.246"	0.246"		
AH	0.240	0.260		0.250"	0.250"	0.249"	0.248"		
AI	2.000	2.020		2.005"	2.005"	2.004"	2.004"		
AJ	0.023	0.043		0.033"	0.033"	0.033"	0.033"		
Accept/Reject									

Measured by: J.F.
Date: 08/08/15

Audited by: [Signature]
Date: 08/08/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]



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D	1.745	1.755		1.749"	1.749"	1.749"			
E	7.990	8.010		8.005	8.005	8.005			
F	0.490	0.510		0.504"	0.504"	0.504"			
G	0.257	0.262		0.258"	0.258"	0.258"			
H	0.375	0.380		0.377"	0.377"	0.377"			
I	0.490	0.510		0.504"	0.504"	0.504"			
J	1.174	1.184		1.182"	1.182"	1.182"			
K	0.558	0.578		0.575"	0.575"	0.575"			
L	1.174	1.184		1.180"	1.180"	1.180"			
M	1.490	1.500		1.499"	1.499"	1.499"			
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Q	0.115	0.135		0.127"	0.127"	0.127"			
R	0.240	0.260		0.251"	0.251"	0.251"			
S	0.115	0.135		0.134"	0.130"	0.130"			
T	0.178	0.198		0.188"	0.188"	0.188"			
U	2.940	2.980		2.954"	2.954"	2.954"			
V	0.230	0.250		0.241"	0.242"	0.241"			
W	0.115	0.135		0.121"	0.121"	0.121"			
X	0.308	0.313		0.310"	0.310"	0.310"			
Y	0.760	0.765		0.760"	0.760"	0.760"			
Z	0.352	0.372		0.372"	0.372"	0.372"			
AA	0.470	0.530		0.500"	0.500"	0.500"			
AB	0.615	0.635		0.633"	0.633"	0.625"			
AC	0.053	0.073		0.063"	0.063"	0.063"			
AD	0.240	0.260		0.250"	0.250"	0.250"			
AE	1.375	1.395		1.389"	1.390"	1.391"			
AF	0.115	0.135		0.125"	0.125"	0.125"			
AG	0.240	0.280		0.246"	0.246"	0.246"			
AH	0.240	0.260		0.248"	0.248"	0.248"			
AI	2.000	2.020		2.004"	2.004"	2.005"			
AJ	0.023	0.043		0.033"	0.033"	0.033"			
Accept/Reject									

Measured by:	J.T.
Date:	08/08/15

Audited by:	28
Date:	08/08/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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RELEASED

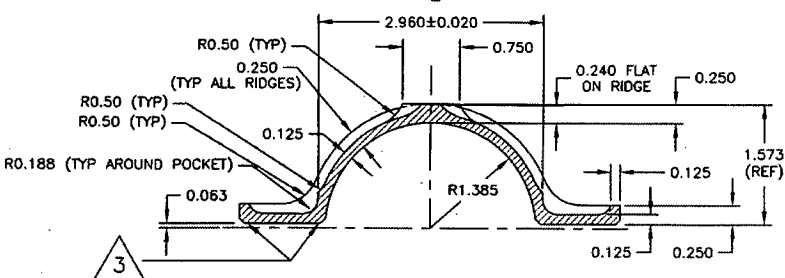
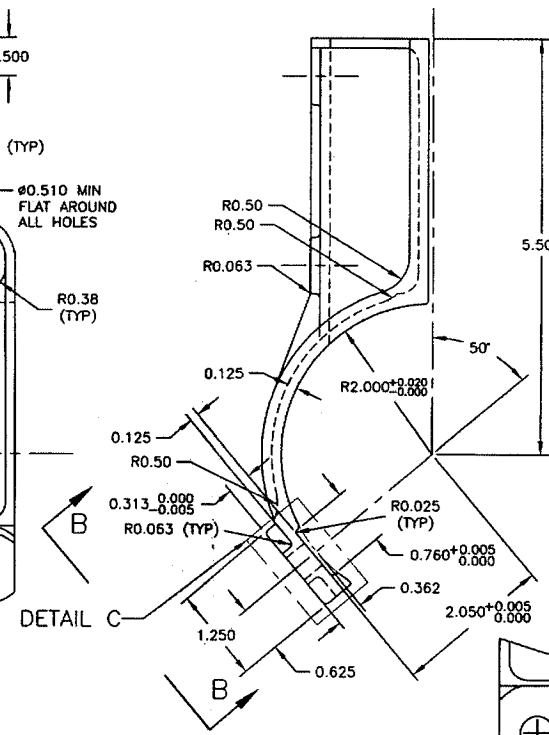
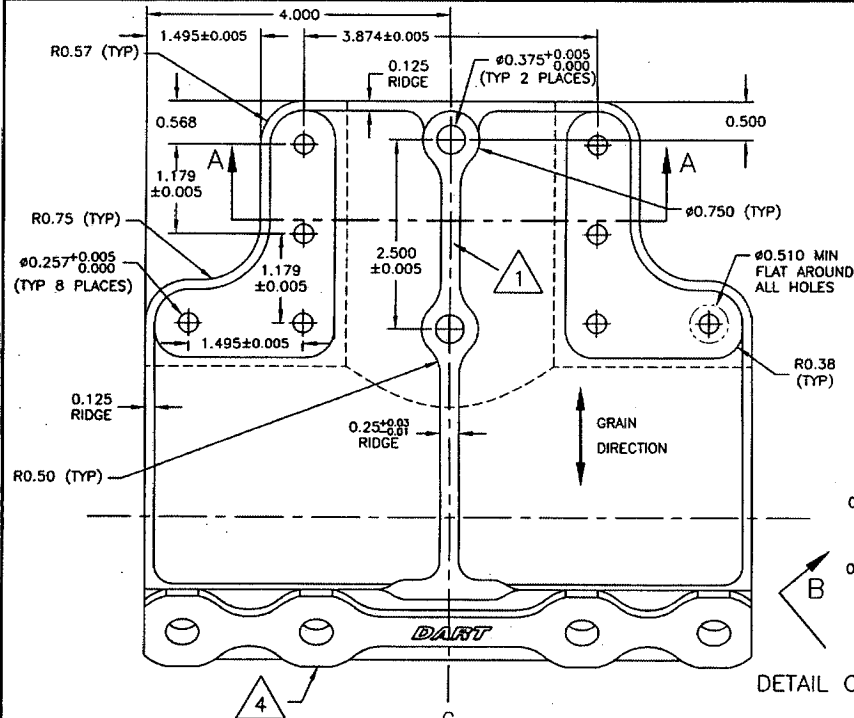
05.12.13

# NOTES

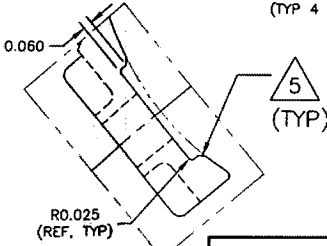
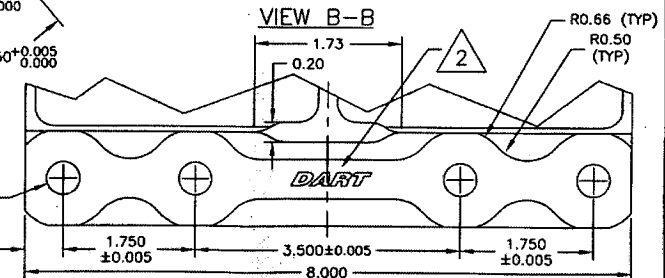
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E



SECTION A-A



DETAIL C  
 SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		OUTER FWD SADDLE

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 SCALE 2:3

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